

Work Order ID 67600

Monday, March 28, 2011 11:54:29 AM



Page 1

Item ID: D2278

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 103-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2278

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2278
Deburr if necessary

☐ Dwg Rev:

F

☐ Prog Rev:

R

☐ 2-

6061 . 086

B11-3-30

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-3-30

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Su103/31

(12)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | | |
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NOTE: Date & initial all entries




Work Order ID 67600

Monday, March 28, 2011 11:54:29 AM

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| | | | | | | |
|----------------|-----------|------------|---|---|---------------|---|
| Item ID: | D2278 | Accept |  | Setup | Start |  |
| Revision ID: | | | | | Stop |  |
| Item Name: | Step Leg | | | | | |
| Start Date: | 3/28/2011 | Start Qty: | 12.00 |  | Cust Item ID: | |
| Required Date: | 3/31/2011 | Req'd Qty: | 12.00 |  | Customer: | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|---|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start |  |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop |  |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|----------------------|---------|-----------|-----------------|---------------|---------------|------------------|----------------|
| 130  HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | <u>✓12</u> | <u>0</u> | <u>11/04/01</u> | |
| 140  QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | <u>12</u> | <u>BR</u> | <u>11-4-4</u> | |
| 150  Packaging Packaging | Identify as per dwg & Stock Location <u>GA</u> Memo | 0.00 0.00 | | <u>SB</u> | <u>11/04/01</u> | <u>(12)</u> | | | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | | | | Sign & Date |
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NOTE: Date & initial all entries

Work Order ID 67600

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Monday, March 28, 2011 11:54:29 AM

Item ID: D2278

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/4 J

11-04-4
(12)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 11:54:35 AM

Page 1

Work Order ID: 67600



Parent Item: D2278

Parent Item Name: Step Leg


Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev:B Now 6061-T6 06-06-23 JLM
IPP Rev C New flat pattern 08.01.11 EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.080  6061-T6 .080 Sheet | | Purchased | No | | | 100 | sf | 126.0000 | 0.9815 | 12.39789 | | | |



B11-3-30

Location

Loc Qty

Loc Code

MAT021

126

116268

60

116700

66

116268

12

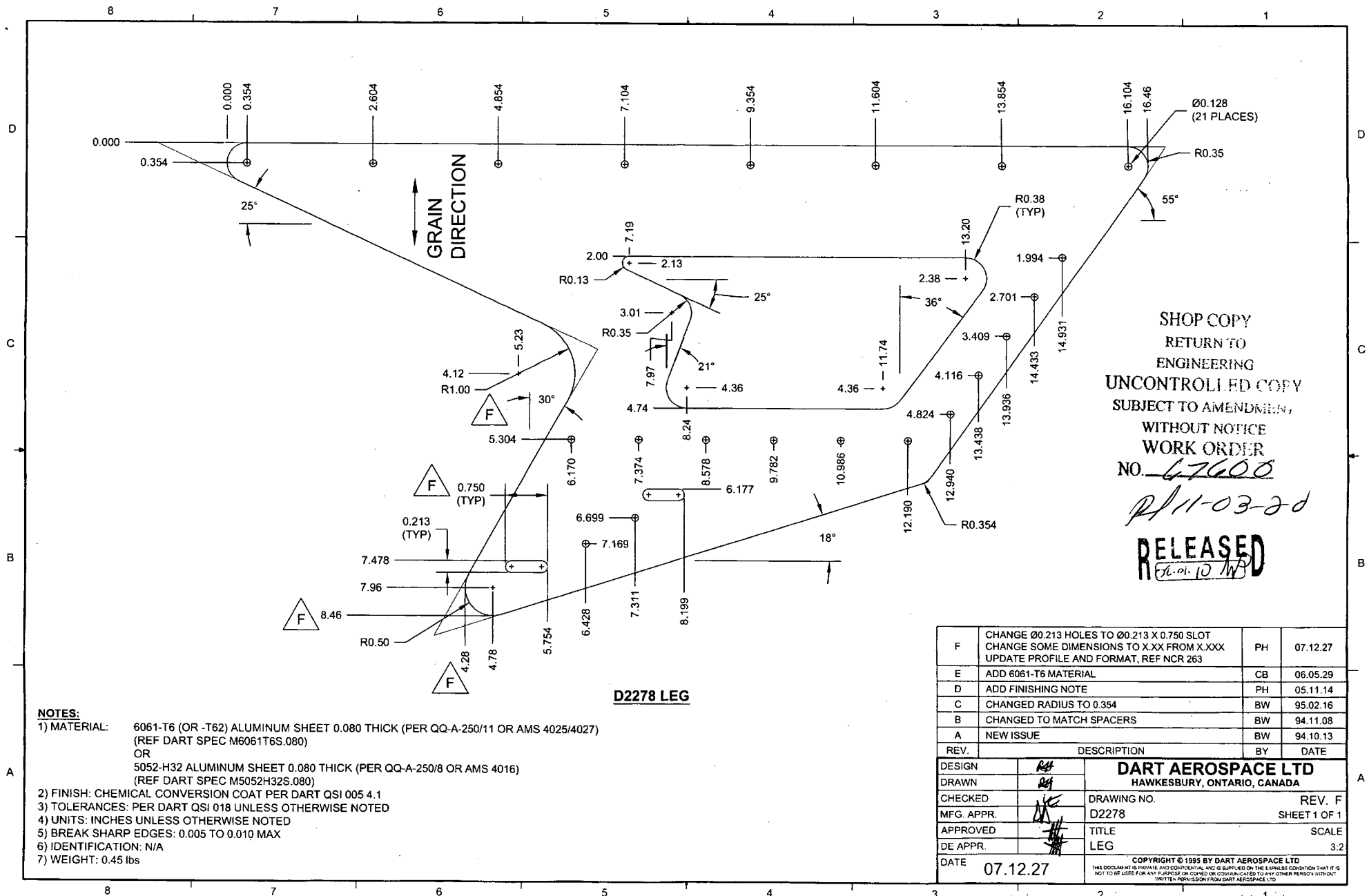
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | | | |
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT,
WITHOUT NOTICE
WORK ORDER
NO. 47608

RELEASE
JUL 01 10 44

| | | | |
|------------|---|---|----------|
| F | CHANGE Ø0.213 HOLES TO Ø0.213 X 0.750 SLOT CHANGE SOME DIMENSIONS TO X.XX FROM X.XXX UPDATE PROFILE AND FORMAT, REF NCR 263 | PH | 07.12.27 |
| E | ADD 6061-T6 MATERIAL | CB | 06.05.29 |
| D | ADD FINISHING NOTE | PH | 05.11.14 |
| C | CHANGED RADIUS TO 0.354 | BW | 95.02.16 |
| B | CHANGED TO MATCH SPACERS | BW | 94.11.08 |
| A | NEW ISSUE | BW | 94.10.13 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>RA</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. 1 D2278 SHEET 1 OF 1 TITLE LEG SCALE 3 | |
| DRAWN | <i>RA</i> | | |
| CHECKED | <i>KE</i> | | |
| MFG. APPR. | <i>KE</i> | | |
| APPROVED | <i>KE</i> | | |
| DE APPR. | <i>KE</i> | COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. NOT TO BE REPRODUCED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 07.12.27 | | |